Work Ord Suly-27-12 9:46		7715		*877				Page 1				
tem ID: Revision ID: tem Name:	D2221-7			Accept	*N900	040	100)* s	etup Star Stop	1/1	S1* S2*	
Start Date: Required Date: Reference:	7/27/12 : 8/17/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:	Process Pl	lan: MLT	Date: 17/07/2	7 Tooling: _ SPC (Y/N):		ate:		R	tun Star Stop	. "I V I	R1* R2*	
Sequence ID/ Work Center I	D .	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Re	evision Nbr										
D2221	Re	ev H	·									
*100 *100* Large Fab Large Fab		Large Fab Memo 1- Cut as po	er dwg D2221	0.00			8 _x	Su	1 13-	03	18	
Ü		•	and remove identification ma	arkings on tube								
110		QC6- Inspect dimension	ns to drawing	0.00				6	13-0		DAS	
110 QC Quality Control		Memo		0.00				<u>_</u>	13.0	3-13	- 	
¹²⁰ *12∩*		Identify as per dwg & S	tock Location: <u>UADO</u>	0.00			O.,		ly 13	ያ ልጋ	10	
Packaging		Memo		0.00			$\mathcal{O} X$		1 EVE	103	10-	

Packaging

												DQA:	D	ate:	
NCR:	Yes	/ No				WORK ORDER NON-CONFORMANCE / UPDATE						QA Closed:	D	ate:	
Work Orde	er:		,			DISPOSITION	AGAINST DEPARTMENT/PROCESS								
Part No						Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite					Water Je d. Eng. Coor e/Packaging Supplie		Engineering Quality Other	
Root					Descri	ption of work order update		Initial Action			Τ	Sign &			
Cause		Date	Step	Qty	c	or Non-conformance	Ch	nief Eng	Descr	ription	1	Date	Verification	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
						F/	AUL	T CATE	GORY						
Landi V		Bending Centre No Cracks Crushed/C	Crimped.		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		1	on Incomplete ions Incomplete/U nance			Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong		-	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Inspection		Tube		Cut Too Short		Misread		┥.	Power Loss/	-		Other	
		Ripples in	Bend			Drill Holes		Offset		_					

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Orde July-27-12 9:46		87715						Page 2				
Revision ID:	D2221-'	7	·	Accept	*N900	040	100)* s	etup	Start Stop		S1* S2*
Start Date: 7/27/12 Start Qty: 1.00 Required Date: 8/17/12 Req'd Qty: 1.00 Reference:			*1* *1*		Cust Item I Customer:							
Approvals:	Proces QC: _	s Plan:	Date:	Tooling: SPC (Y/N):	D:	F	Run	Start Stop	*N *N	R1* R2*		
Sequence ID/ Work Center II 130 *130* QC Quality Control)	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp

N 13-03-19

												DQA:	Date			
NCR:	Yes	/ No					WORK ORDER NON-O	COI	NFORM	MANCE / UP	DATE					
												QA	Closed:	Date	<u>:</u>	
Vork Ord	er.					į	DISPOSITION AGAINST DEPAI							/PROCESS		
VOIK OIG	C1.				·····		Rework		Skid-tube	Crosstube			Water Jet	Engineering		
Part	No.						Scrap	ı	Machining	Small Fab		Pro	d. Eng. Coor.	Quality]	
							Use-as-is		noforming	Finishing	_	Rec/Stor	re/Packaging	Other	↓ ∣	
NCR	No.		· (* -				Work Order Update]		Large Fab	Composite			Supplier		╛╽
Root					Desc	crip	otion of work order update		nitial	Ac	tion	S	ign &			
Cause		Date	Step	Qty		C	or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Inspector	
oc/Data								ł		•						
quip/Tooling	L													·		
perator	_												ļ			
laterial	$ldsymbol{eta}$															
etup																
ther	<u> </u>															
rocess	├-	•														
upplier	⊢											į		,		
raining	\vdash															
napproved	<u> </u>		l	l					T CATE	EOBA				ł		
Landi	na (Geor					General	AUL	.I CATE	JONT						
Latiu	Tig \	Bending			ſ		Bend	Г	Grain		Г	\neg_{α}	alized	Γ	Pressure/Forced	
		Centre No	nt Concer	ntric to (0/5		BOM/Route	\vdash	Hardwa	re				tolerance	Temperature/Cur	e
	\vdash	Cracks	, conce		``		Broken/Damaged	-	1	on Incomplete		_	rt Incorre		Weld	
	F	Crushed/0	Crimped		Ì		Burrs	\vdash	1	ions Incomplete/	/Unclear		rt Lost/Mi	<u> </u>	Wrong Stock Pulle	ed
		Cuffs			Ì		Contamination		Mainte	•		—;	rt Moved			
		Heat Trea	ıt		ļ		Countersink		Mislabe		Ì		sitioned V	Vrong		
	\vdash	Inspection		Tube	İ		Cut Too Short		Misread		ł	_	wer Loss/		Other	
		Ripples in			İ		Drill Holes		Offset		ı		·	, .	1	
		Torque W	aves in E	xtrusio	n [Drawing		Out of (Calibration						
		Turning Sequence					Finish		Out of S	Sequence						

Outside Dimensions

Wave/Twist in Tube

Folio

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Picklist Print

July-27-12 9:46:01 AM

Page 1

Work Order ID:

87715

Parent Item:

D2221-7

Parent Item Name:

Rib

Start Date: 7/27/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

Comments:	IPP Rev:A New	Issue 08-12-02	DD verif	ied by:EC									
Component Item ID/ Item Name	Replacement Item JD	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Ser _I ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	2,095.6831	4.6042	4.846526	3		
304 SQ Tube .75x.75x.06	55W									1222		11 01	

Location Loc Qty Loc Code MAT 978.9473 112398 122051 978.9473 MAT017 1075.735784 120267 23.1978140 120633 52.53797 122468 1000 MAT018 41 7636 41

												DQA:	Da	ate: _		
NCR:	es /	No				WORK ORDER NON-C		NFORM	ANCE / UP	DATE					-	
												QA Closed:	Da	ate:		
Morle Orde			•			DISPOSITION	AGAINST DEPARTMENT/PROCESS									
Work Order:						Rework	1		Skid-tube	Crosstube		}	Water Jet	. 🗀	Engineering	
Part N	do.					Scrap			Machining	-	Pro	d. Eng. Coor.	\vdash	Quality		
14161	··· —					Use-as-is		1	noforming	Small Fab Finishing	_	Rec/Store/Packaging			Other	
NCR N	No.					Work Order Update			Large Fab	Composite	_		Supplier	-		
<u> </u>										· •						
Root			,		Descri	ption of work order update	ı	Initial	Act	tion		Sign &				
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desci	ription		Date	Verification	n	QC Inspector	
Doc/Data			i	·				:								
Equip/Tooling]		
Operator																
Material																
Setup			i													
Other																
Process																
Supplier																
Training	Ш]									
Unapproved					ļ											
						F	AUL	LT CATE	GORY		_					
Landi						General	_	7		-		7			1	
	$\boldsymbol{\vdash}$	ending				Bend		Grain		ļ		Ovalized			Pressure/Forced	
	_		t Concer	ntric to	o/s	BOM/Route		Hardwa	re	ļ		Over/Under	tolerance		Temperature/Cure	
	Cı	racks				Broken/Damaged		Inspecti	on Incomplete	ļ		Part Incorred	ct		Weld	
	L C	rushed/0	Crimped.			Burrs		Instructions Incomplete/Unclear Page 1				Part Lost/Mi	ssing	L	Wrong Stock Pulled	
	Cuffs					Contamination Maintenance						Part Moved				

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

ITEM QTY X D2221 2 D2221-1 D2221-5 3 2 D2221-7 2 D2232-3 2 D2235-1 D2581 D3442-1 D3825-041 10 D3826-041 D3827-041 12 D3833-1 D3832-1 SHOP COPY RETURN TO **ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER MLJ NO. 87715MLJ 12/07/27 **D2221 BASKET BASE ASSEMBLY (AS350)** (MESH SHOWN LOCALLY FOR CLARITY)

REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A.A. B-B AND CC (ZN C6-3). C2-3 AND 6-3.9; REVISED DETAIL, DZN B7-4); ADDED DETAIL E (ZN AS-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR DZ221-1-5-7; (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3425-041 REPLACES D2221-3/D327-3, D3826-041 REPLACES D2221-3/D327-3, D3826-047 REPLACES D2225-1/D3227-3, D3836-047 REPLACES D2225-1/D325-05-3, D3836-047 REPLACES D225-1/D3527-3, D3836-047 REPLACES D225-1/D3527-3, D3836-047 REPLACES D225-1/D3527-3, D3836-1/D353-1/D3533-1, REASON: SATISFY "LEAN MANUFACTURING" PROGRAM. МВ 08.09.18 MATERIAL FOR -1, -3, -5 & -7 WAS 0,060 WALL: TOLERANCE FOR 96 00 DIM WAS +4-0.01 AND 56 00 DIM WAS REF (ZM 84-2); NOTE 5 TRANSFERED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERED TO "B" FORMAT AJS 08.06.16 ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET PH 05.06.07 CHANGE HINGE CP 01.04.19 D CHANGE LATCH BW 96.06.21 SEPARATE BASKET AND LID С KH 95.11.21 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD

DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED D2221 MFG. APPR SHEET 1 OF 5 TITLE APPROVED BASKET BASE ASSEMBLY (350) NTS DE APPR. DATE 08.09.18

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WITH THE PRESSON FROM DARK ARROSPACE, LTD.

9) MASK ALL HOLES PRIOR TO POWDER COATING

3

NOTES: 1) MATERIAL: N/A

6) IDENTIFICATION: N/A

8) WEIGHT: 42.00 lbs APPROX

D

P/N

RIB

RIB

RIB

RIB

SHIM

BASKET HINGE

MOUNTING BRACKET

RIB/GUSSET ASSY

MESH (BASE)

RIB ASSY (INBOARD)

RIB ASSY (BASKET END)

MESH, BASE END FACE

DESCRIPTION

BASKET BASE ASSEMBLY (AS350)

1) MATERIAL: IVIA 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

REV. H







